

Work Order ID 129063

Wednesday, January 28, 2015 9:05:38 AM

129063

Page 1

Item ID: D3849-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Wearplate Aay, Std Gear
 Start Date: 1/28/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/28/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-01-28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3849	E								

110 0.00 ***110*** 6 15-05-20 MAL

Large Fab Memo 0.00
 Large Fab 1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849
 2059 B Hardcoat Welding Rod
 BATCH#: M131995
 2- Weld D3901-1 bar to wearplate as per dwg D3849
 304 S.S. Welding Rod
 BATCH #: M128077
 3- Transfer drill holes as per dwg
 4- Cut excess bar material if necessary

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 ***120*** 6 15-5-25 DAS
 QC Memo 0.00 **50**
 Quality Control **9-89**

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	1- Apply a layer of TEXTURE COATING as per dwg								
	BATCH: 131816								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
41
9-89
15-5-26
MAY 27 2015

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Item ID: D3849-043 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Aft Wearplate Aay, Std Gear
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Required Date: 1/28/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MAY 28 2015

MAY 27 2015

Picklist Print

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Parent Item: D3849-043

D3849-043

Parent Item Name: Aft Wearplate Aay, Std Gear

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
12.09.11 AS PER DWG REV.D DD VERF:JLM IPP Rev:B
AS PER DWG REV.E DD VERF:JLM IPP Rev:C 14.11.26

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3849-3		Manufactured	No			110	Each	17.0000	1	6			

D3849-3

Plate

~~B124077 x12~~

Location	Loc Qty	Loc Code
WA001	9	
102972	1	
124360	8	
WA002	8	
<u>126318</u> x 6	8	

x6

15-05-20 MAL

D3901-3

Manufactured No

110

Each

20.0000

2

12

D3901-3

Bar

Location	Loc Qty	Loc Code
WA001	20	
<u>124077</u>	<u>12</u>	
124332	8	

x12

15-05-20 MAL

8

7

6

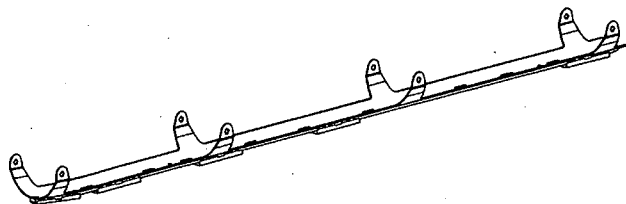
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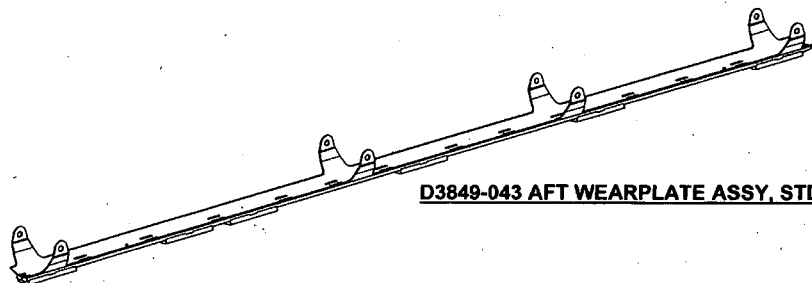
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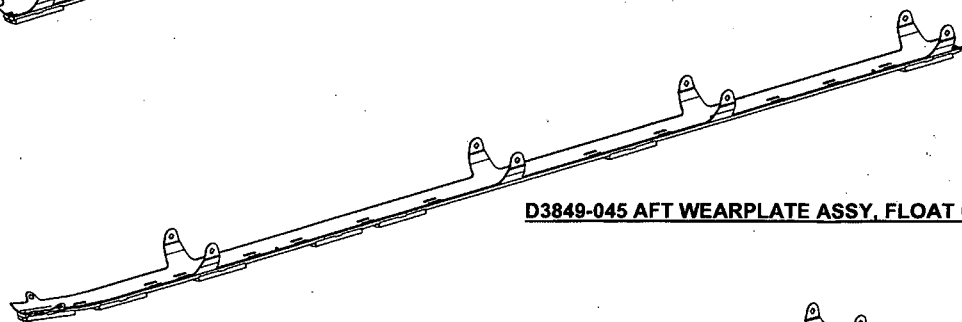
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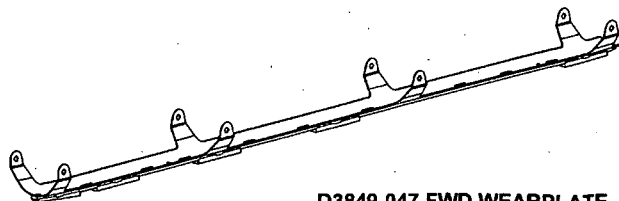
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1			1	D3901-1	BAR
16		2			D3901-3	BAR
17			2		D3901-5	BAR
21	A/R	A/R	A/R	A/R	2059B	HARDCOAT
22	A/R	A/R	A/R	A/R	TEXTURED COATING	SEALANT

△ E

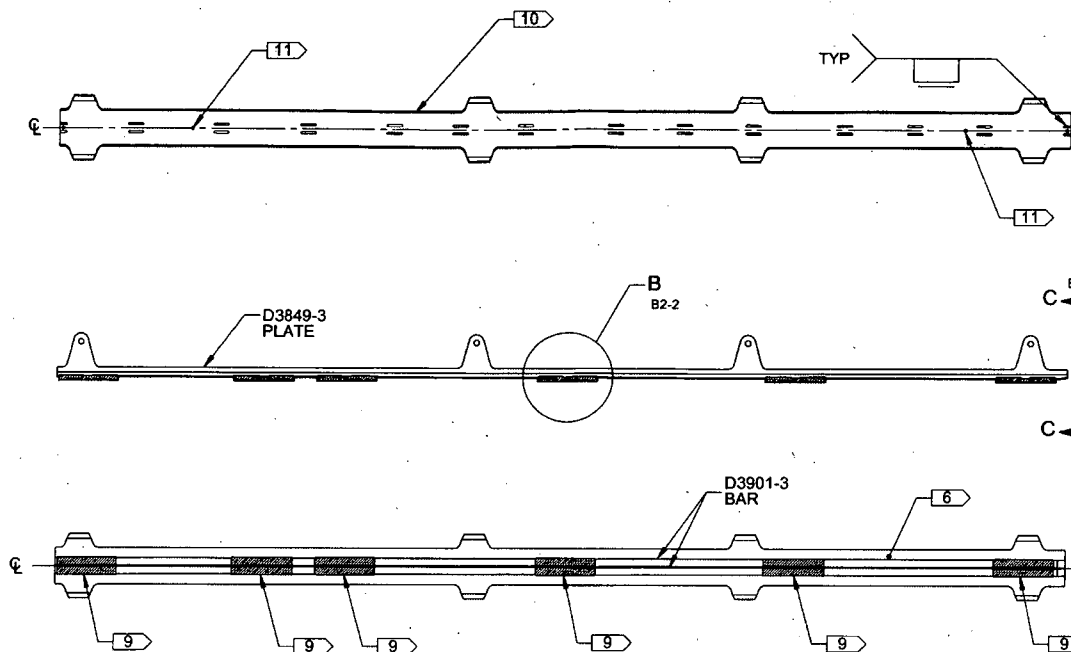
RELEASED

2014 NOV 24 4P
ECN 14-628

129063 MJS
150128

E	TEXTURED COATING WAS 4714 ROCKGUARD (BOM TABLE), CHANGE NOTE 10 (SH 2, 3, 4, 5), 8.49 LBS WAS 7.66 LBS (SH 3, NOTE 7), 10.25 LBS WAS 8.93 LBS (SH 4, NOTE 7), 4.66 LBS WAS 4.60 LBS (SH 5, NOTE 7)	AK	14.08.07
D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3901-1/3/5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9)	DC	12.08.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS, ADDED DOUBLE SLOTS AND D3801-3/5 BARS ON -043/-045, UPDATED DETAIL VIEWS, CHANGED WELD DETAILS (ZN B2-2), REMOVED D3848-1/3/5/7 GASKETS, ADD ROCKGUARD COATING, REMOVE FINISH.	DC	12.08.21
B	REVISED FLAT PATTERN: Ø0.375 WAS SLOT HOLE ON D3849-1/3/5/7 (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-5, A4-9); ADD SECTION K-K (ZN C5-10), 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3849	SHEET 1 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	14.08.07	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

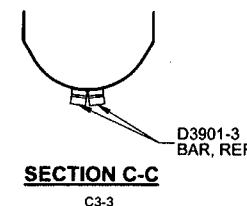
APPROVED



D3849-043 AFT WEARPLATE ASSY, STD GEAR

RELEASED

2014 NOV 24



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-043 = 8.49 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9.
- 11) TRANSFER DRILL $\varnothing$ 0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BARS

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AK	KENT, WA	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3849	SHEET 3 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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